

Work Order ID 52595

October 2, 2009 11:20:36 AM



Page 1

Item ID:	D3564-5	64	Accept		Setup	Start	
Revision ID:	D					Stop	
Item Name:	Wearshoe						
Start Date:	02/10/2009	Start Qty:	12.00		Cust Item ID:		
Required Date:	20/10/2009	Req'd Qty:	12.00		Customer:		
Reference:							

Approvals:	Process Plan:		Date:	09-10-2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100

 Waterjet
 FLOW CNC Waterjet
 FLOW WATER JET
 Memo
 1-Cut as per Dwg D3564 ☒ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
 Deburr if necessary

0.00

0.00

189-10-14

110

 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo

0.00

0.00

189-10-14

120

 QC
 Quality Control
 QC8- Inspect parts - second check
 Memo

0.00

0.00

2) 8/21/19

(+15) 12/21/19
 one
 per
 template
 8

W/O: 52595

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/10/19	105	took at qty x1 for template for inspection	S	07/10/19	1		S 07/10/19

Part No: D3564-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52595

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Page 2

Item ID: D3564-5

Accept



Setup Start



Revision ID: D

Stop



Item Name: V. earshoe

Start Date: 02/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 20/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

15

0

Brake NC

Memo

0.00

Brake NC

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT8157 JB 09/10/20

140

0.00



QC5- Inspect part completeness to step on W/O

278 09/10/20

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

45

0

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

27 JH 09/10/20

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:00am FINISH TIME: 7:30am OVEN TEMPERATURE: 320°F

11109091

15

0

Picklist Print

October 2, 2009 11:20:35 AM

Page 1

Work Order ID: 52595



Parent Item: D3564-5RevD



Parent Item Name: Wearshoe



Start Date: 02/10/2009

Required Date: 20/10/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	133.4426	18.9474	85.7632		
												
304/316 Sheet .063											189-10-14	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	133.4425737	
106860	16.018	
111924	25.1689737	
112442	59.4926	
112567	32.763	112567

DART AEROSPACE LTD		Work Order:	52595
Description: Wearshoe		Part Number:	D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

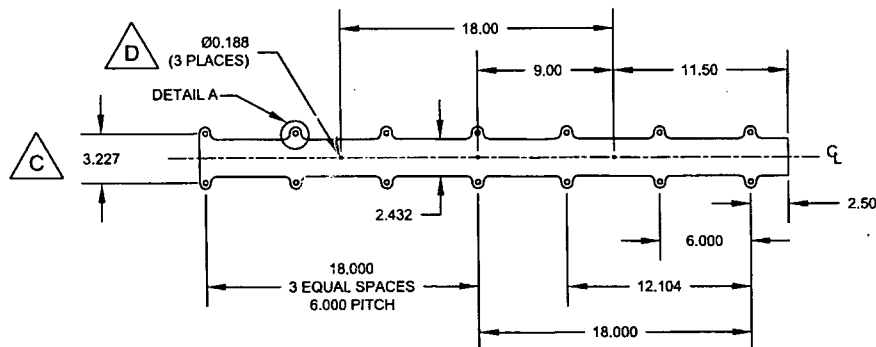
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

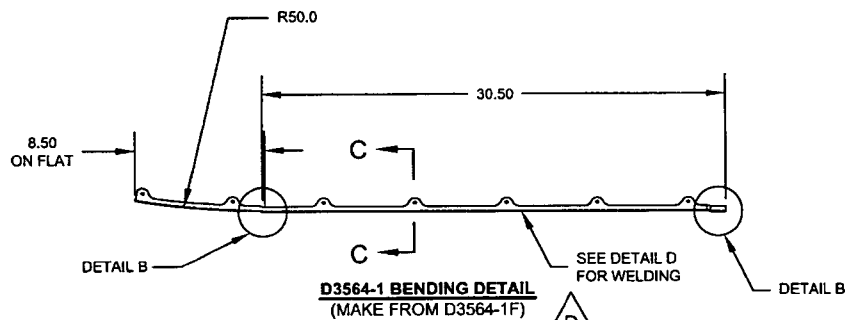
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	✓			
6.75	+/-0.030	6.75	✓			
10.00	+/-0.030	10.00	✓			
20.00	+/-0.030	20.00	✓			
30.00	+/-0.030	30.00	✓			
2.50	+/-0.030	2.50	✓			
3.227	+/-0.010	3.223	✓			
38.500	+/-0.010	38.500	✓			
5.500	+/-0.010	5.500	✓			
2.50	+/-0.030	2.50	✓			
2.432	+/-0.010	2.439	✓			
0.300 x 0.300	+/-0.010	303 x 304	✓			
Ø0.188	+0.005/-0.001	.191	✓			
R0.375	+/-0.010	.375	✓			
0.063	+/-0.010	.060	✓			

Measured by:	JB	Audited by:	S	Prototype Approval:	N/A
Date:	9-10-14	Date:	09/10/17	Date:	N/A

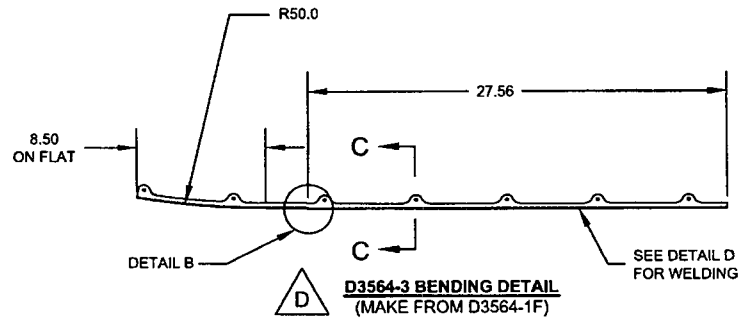
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DB	DB



D3564-1F FLAT PATTERN



**D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)**



**D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)**

SHOP COPY
RETURN TO
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WORK ORDER
NO. 52595

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

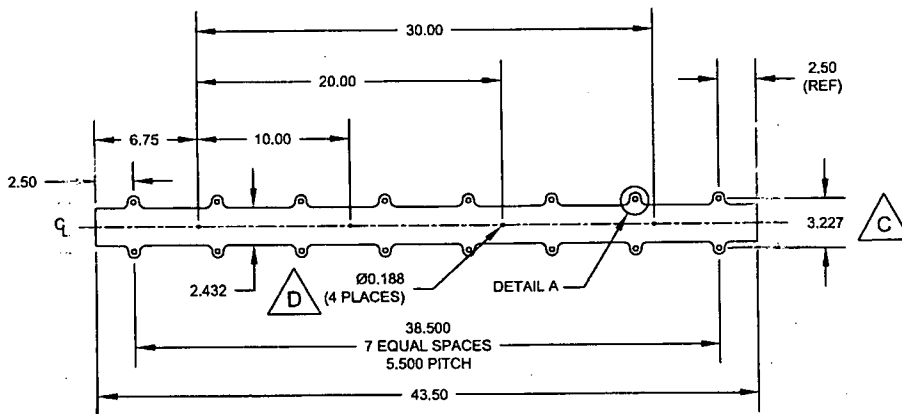
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8, PG3 B5,C5; ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

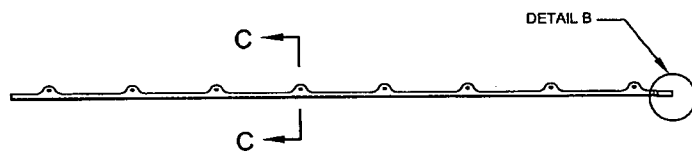
DRAWING NO. D3564
TITLE WEARSHOE
REV. D
SHEET 1 OF 3
SCALE 1:8

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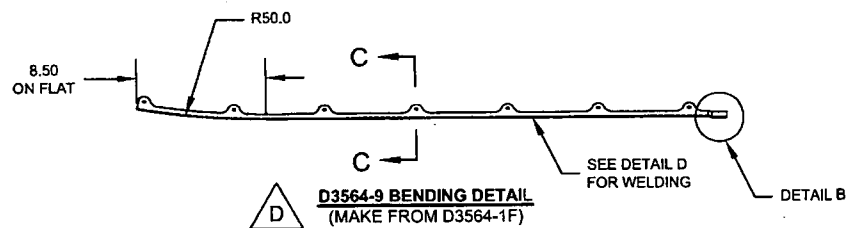
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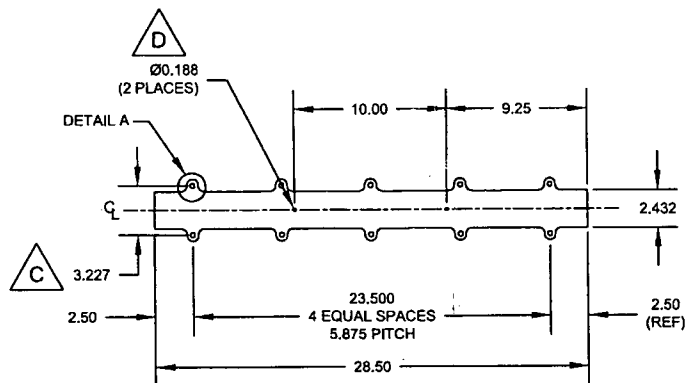
D3564-5F FLAT PATTERN



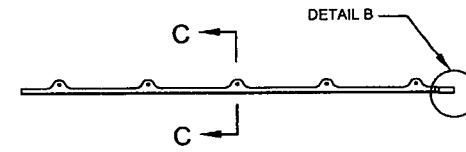
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



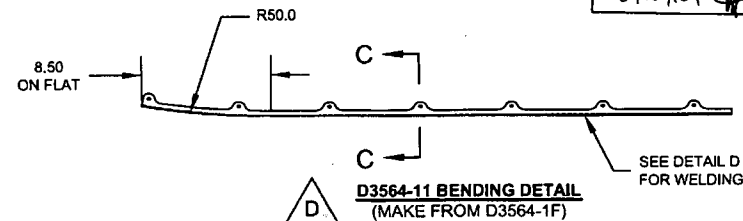
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

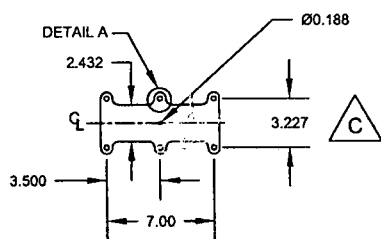
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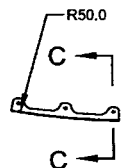
07.09.04

DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>CB</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>PH</i>	D3564	SHEET 2 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	WEARSHOE	1:8
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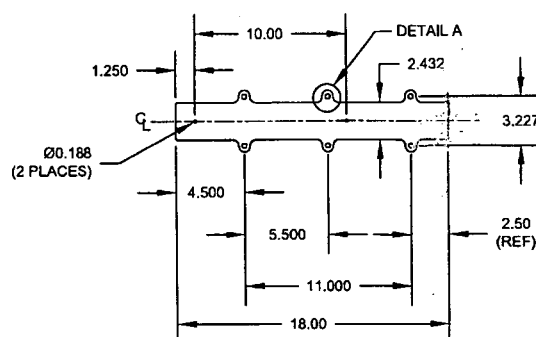
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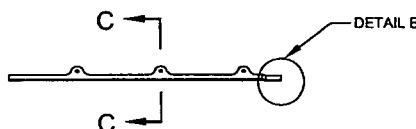
D3564-13F FLAT PATTERN



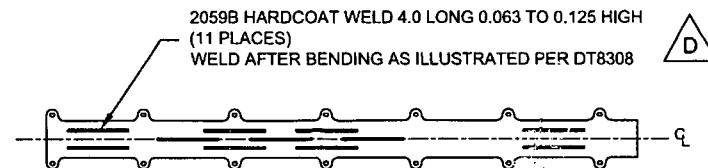
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

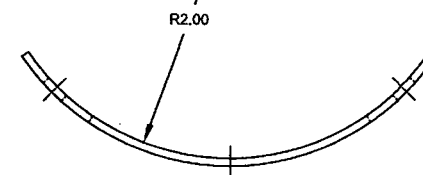


DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

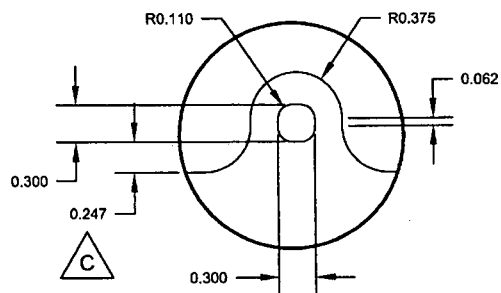
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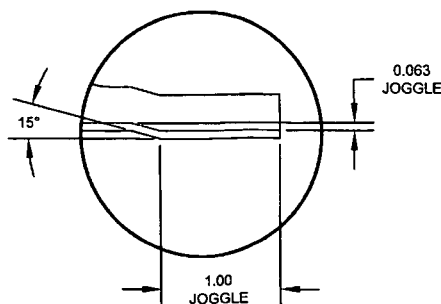
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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